



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Cut as per

D3639-4

Job Sheet 172225



Part No: D3639-4

Job Qty: 8 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/14/18

Job Tracking No:

Due Date: 2/16/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		2/15/18	0.00	0.00	Start Up Waterjet		<i>SC 18/02/14</i>
100	Waterjet	8 pcs		2/15/18	0.00	0.66	Waterjet1		<i>SC 18/02/14</i>
110	QC	8 pcs		2/15/18	0.00	0.00	QC2 Waterjet-2		<i>SC 18/02/14</i>
120	QC	8 pcs		2/15/18	0.00	0.00	QC8-3		<i>38</i>
130	Brake NC	8 pcs		2/15/18	0.00	0.32	Brake NC 1		<i>DA9-88 FL</i>
140	QC	8 pcs		2/15/18	0.00	0.00	QC5		<i>38</i>
150	HandFinish	8 pcs		2/16/18	0.00	0.54	HandFinish1		<i>REB 18-02-21</i>
160	QC	8 pcs		2/16/18	0.00	0.00	QC7-2		<i>38</i>
170	Packaging	8 pcs		2/16/18	0.00	0.00	Packaging3-1		<i>5+234A JV 9-80</i>
180	QC21-SA	8 Ea		2/16/18	0.00	0.00	QC21		<i>FEB 22 2018</i>

Part Op 100 - 1-Cut as per Dwg D3639 Dwg Rev: *A* Prog Rev: *A* 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per Dwg D3639

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - QC7-Inspect Chemical Conversion Coat

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	3.4216 sf (.4277 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	3	130	0

Part Specifications

Specifications could not be found.



Container No: S042322



Part: D3639-4

Serial No/Batch: S042322

Revision: D3639

Inspector:

Dart Aerospace Ltd.
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Date: 02/14/18 11:51 AM

DART AEROSPACE LTD		Work Order:	172225
Description: Doubler		Part Number:	D3639-4
Inspection Dwg: D3639 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	Ø0.625	1		USE 02	
Ø0.191	+0.005/-0.001	Ø0.192	1		Type	
Ø0.098	+0.004/-0.001	Ø0.099	1			
0.45	+/-0.030	0.45	1			
1.350	+/-0.010	1.382	1			
2.25	+/-0.030	2.25	1			
3.15	+/-0.030	3.15	1			
4.05	+/-0.030	4.05	1			
4.95	+/-0.030	4.95	1			
5.85	+/-0.030	5.856	1			
6.75	+/-0.030	6.75	1			
7.65	+/-0.030	7.654	1			
8.55	+/-0.030	8.56	1			
9.350	+/-0.010	9.354	1			
9.45	+/-0.030	9.455	1			
10.350	+/-0.010	10.351	1			
11.25	+/-0.030	11.25	1			
12.15	+/-0.030	12.15	1			
12.85	+/-0.030	12.85	1			
13.86	+/-0.030	13.86	1			
13.96	+/-0.030	13.96	1			
0.805	+/-0.010	0.806	1			
1.00	+/-0.030	1.00	1			
2.100	+/-0.010	2.101	1			
3.30	+/-0.030	3.30	1			
2.000	+/-0.010	2.001	1			
2.590	+/-0.010	2.592	1			

Measured by:	56	Audited by:	DAS 38	Prototype Approval:	N/A
Date:	18/02/14	Date:	FEB 14 2014	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	